

Work Order ID 57510



Page 1

April 8, 2010 7:16:46 AM

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 4/08/10 Start Qty: 50.00



Cust Item ID:

Required Date: 4/14/10 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3537	Rev C	

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

HB 10-4-8

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr
if necessary*304 - 063**(60)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

HB 10-4-8

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S10/04/09

Quality Control

*counts**+60*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April 8, 2010 7:16:46 AM



Page 2

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Start Date: 4/08/10

Start Qty: 50.00



Cust Item ID:

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Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

NC BRAKE

0.00

Brake NC

Memo

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-
Identify as D3537-1

SB

10/04/12

60

0

140



Large Fab

0.00

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat

□1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any
weld that penetrated through Wearpadif necessary

114032

EL 10-4-15 X60

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Quality Control

0.00

8/04/12

cont'd

X60

Dart Aerospace Ltd

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Page 3

April 8, 2010 7:16:47 AM

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Start Date: 4/08/10 Start Qty: 50.00



Cust Item ID:

Required Date: 4/14/10 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S10/04/15

0.00

(160)

counter

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

1112589

0.00

Memo

oven temperature:

START TIME: 8:15AM FINISH TIME: 8:45AM OVEN TEMPERATURE: 320°F

=) M 10/04/16

X60 φ

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

(60) 8/14/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 7:16:45 AM

Page 1

Work Order ID: 57510



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 4/08/10

Required Date: 4/14/10

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	34.2000	5.5789	6.7 	4/8-4-8	

304/316 Sheet .063

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT20	34.2
113295	34.2

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S7S10
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

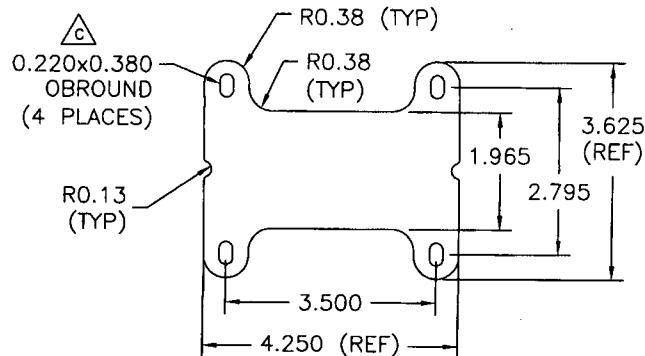
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

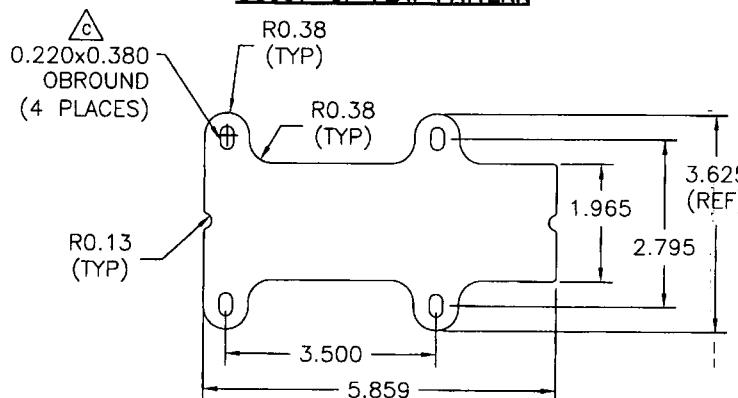
Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-4-9	Date:	10-4-9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>

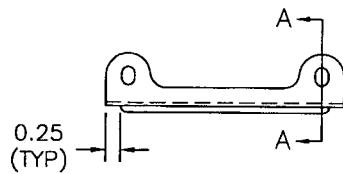
D3537-1F FLAT PATTERN



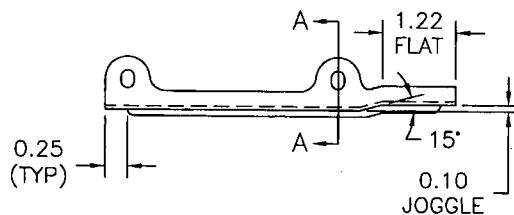
D3537-3F FLAT PATTERN



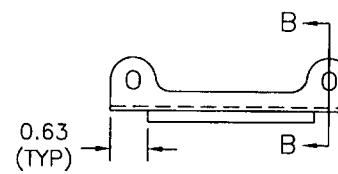
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



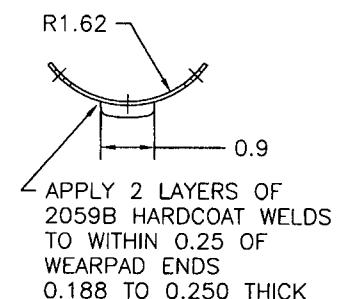
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



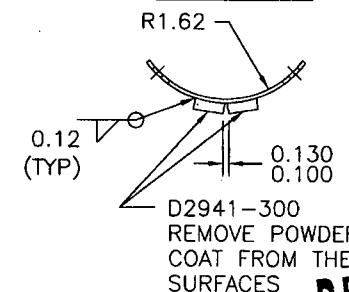
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

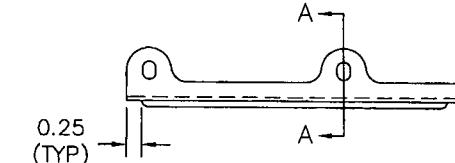


SECTION B-B



RELEASED
07.05.08 AM
per E&L
952

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DRAWN BY	PJ	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	4	APPROVED
DRAWING NO.	D3537	REV. C
DATE	07.04.13	SHEET 1 OF 1
TITLE	WEARPAD	SCALE
		1:2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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